

Wednesday, 19/11/2008 2:17:33 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SHORT STEP ASSEMBLY HIGH SKID RH
Job Number : 43555	
Estimate Number : 10720	
P.O. Number :	Part Number : D350591214
This Issue : 19/11/2008 S.O. No. :	Drawing Number : D3078 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / /	Drawing Revision : A
Previous Run : 43088	Material :
Written By :	Due Date : 10/12/2008
Checked & Approved By : <u>JLD 08-11-19</u>	Qty: <u>split</u> 4 Um: Each
Comment : Est Rev:B 05.10.14 Modified step 10 KJ/EC	
Est Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM	
Est Rev:C 06-06-27 Revised as per DSI9340 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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for JLD 08.12.03



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-214 CHG002

Split

2.0	D2622120C	Step Extrusion
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Comment: Qty.: 0.5000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
.5 D2622-120	Extrusion	42155 (1) 39316 (2)*

SAD 08-11-21

Y

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078

2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.

3-Deburr

SAD 08-11-21

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

Split 1/21

Wednesday, 19/11/2008 2:17:34 PM
Dawson

Process Sheet

Order: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY HIGH SKID RH

Job Number: 43555

Part Number: D350591214

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	D30671	End Plate
✓		
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3067-1 End Plate <u>B41032</u> (4X)</p>		
6.0	D30631	Support
↓		
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3063-1 Support <u>B41031</u> (4X)</p>		
7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
<p>Comment: LARGE FABRICATION RESOURCE 1 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3078 A/R Aluminum Rod <u>M109213</u> <u>M109855</u> SP 08.11.24 (4X) 3-Grind End Plate flush SAD 08-11-25 (4X)</p>		
8.0	QC9	VISUAL WELDING INSPECTION
<p>Comment: VISUAL WELDING INSPECTION <u>QC 08-11-26</u> (4X)</p>		
9.0	QC5	INSPECT WORK TO CURRENT STEP
<p>Comment: INSPECT WORK TO CURRENT STEP <u>QC 08/11/26</u> (4X)</p>		
10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
<p>Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <u>FD 08/11/27</u> (4X)</p>		



Process Sheet

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Drawing Name: SHORT STEP ASSEMBLY HIGH SKID RH

Job Number: 43555

Part Number: D350591214

Job Number:



Seq. #: Machine Or Operation:

11.0

QC3

Description:

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION



(4X)

12.0

D3065041

Step Leg Assembly Hi



M-1 08/11/27

Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3065-041

Step Leg Assy

B41445

13.0

D30661

Spacer



SAD

08/11/27

Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3066-1

Spacer

B42345

14.0

MS20600AD4W4

Rivets



SAD

08/11/27

Comment: Qty.: 16.0000 Each(s)/Unit Total: 64.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 MS20600AD4W4

Rivet

M109545

15.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



SAD

08/11/27

Comment: LARGE FABRICATION RESOURCE 1
Rivet Leg Assembly as per Dwg D3078.

16.0

QC5

INSPECT WORK TO CURRENT STEP



SAD

08/11/27

Comment: INSPECT WORK TO CURRENT STEP

17.0

D30671

End Plate



08/11/27 (4X)

Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description

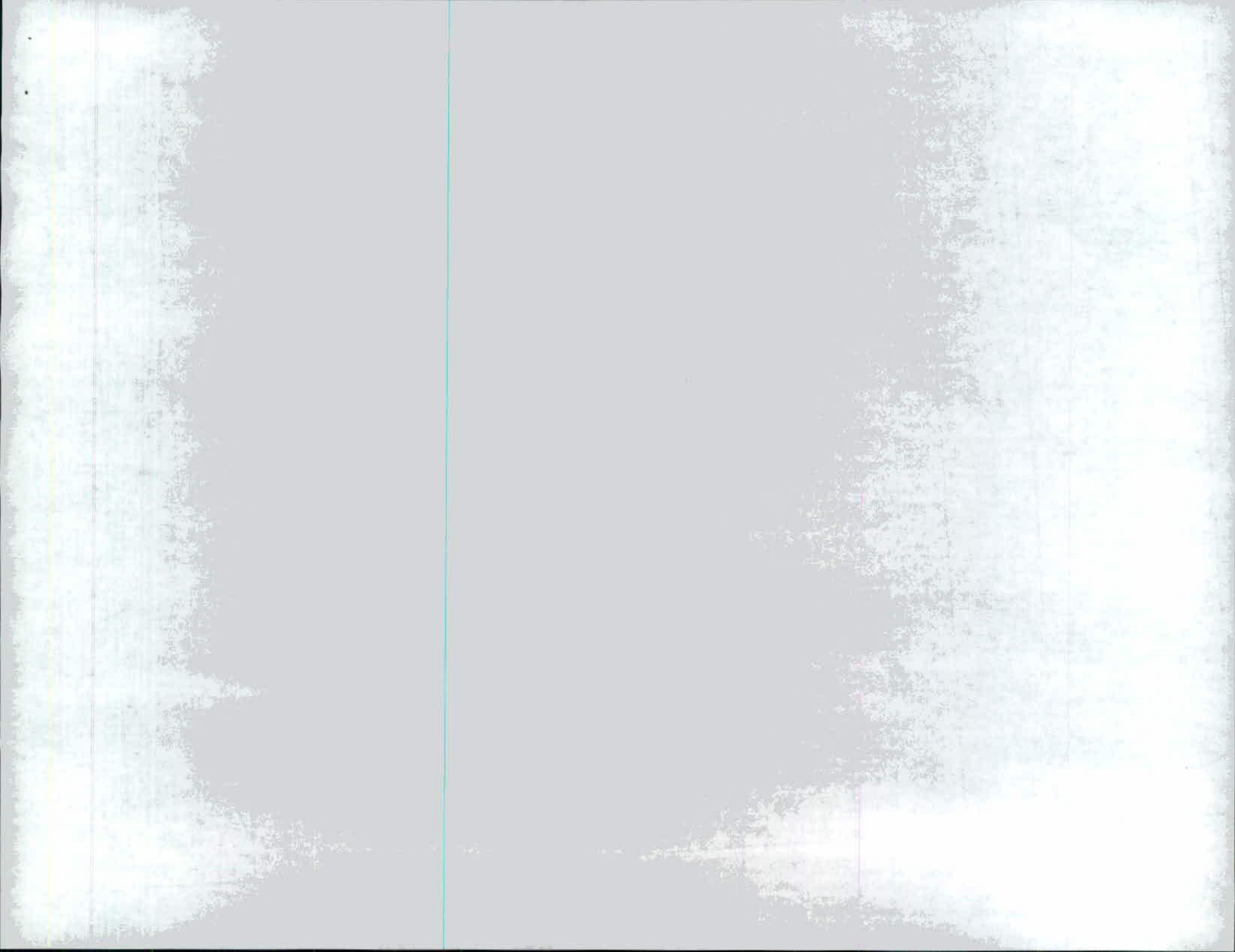
Batch

1 D3067-1

End Plate

B41032

SP 08-12-01



Job Number: 43555

Part Number: D350591214

Job Number:



Seq. #: Machine Or Operation: Description :

18.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3078

A/R Aluminum Rod M104855

SP 08.12.01

(4)

4-Grind End Plate flush

SAD 08-12-02

(4X)

19.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Qd 08-12-02

CE 08/12/02

(4)

20.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sad 12/02

(4XRH)

21.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch Up Chemical conversion

M-1

08/12/03

(4XRH)

22.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:50
320°F
4:20

M-1

08/12/03

(4XRH)

23.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3078 and QSI 005 4.4

M-1

08/12/04

(4XRH)

Wednesday, 19/11/2008 2:17:34 PM

Julie Dawson

Process Sheet

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Part Number: D350591214

Job Number:



Seq. #: Machine Or Operation: Description :

24.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

08-12-08 K4

25.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

26.0 D22303 Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2230-3 Clamp 42316

8/12/12

27.0 D22301 Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2230-1 Clamp 44119

B43444 40% 8/12/17

B41815 YX

SC

28.0 D2732 Rubber Extrusion



Comment: Qty.: 1.0000 f(s)/Unit Total: 4.0000 f(s)

Rubber Extrusion

4 X 3"

Batch: B38509

SC

29.0 D2856400 Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total: 2.4000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2856-400(7.2") Abrasion Strip B4207C

8/12/12

SC

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Job Number: 43555

Part Number: D350591214

Job Number:



Seq. #:	Machine Or Operation:	Description :
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30.0	AN335A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-35A Bolt M108827

31.0	AN411A	Bolt
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 AN4-11A Bolt M106605

32.0	AN413A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

Batch: M109285

33.0	AN960JD10	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10 Washer M109001

34.0	AN960JD416	Washer
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN960JD416 Washer M109249

35.0	MS21042L3	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) M109031

8/12/12

Process Sheet

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Job Number: 43555

Part Number: D350591214

Job Number:



Seq. #:	Machine Or Operation:	Description :
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36.0	MS21042L4	Nut
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4x

Comment: Qty.: 6.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS21042L4 Nut (or -4)

M188145

8/12/12

SP

37.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

508/12/17

38.0	PACKAGING 1	PACKAGING RESOURCE #1
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2x

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-214

Location:

PPP Rev:

6/12/12

SP

39.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/12/18

Job Completion



MF 08-12-17



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3078	REV. A SHEET 1 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, HI SHORT SCALE NTS	
A	02.09.11	NEW ISSUE	

RELEASED
02.07.20 *[Signature]*

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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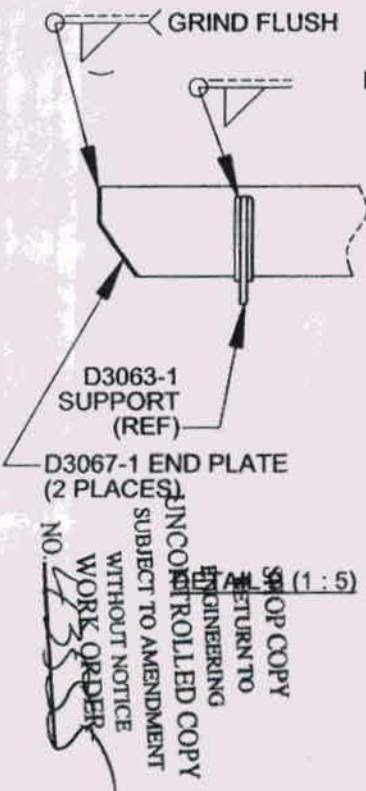
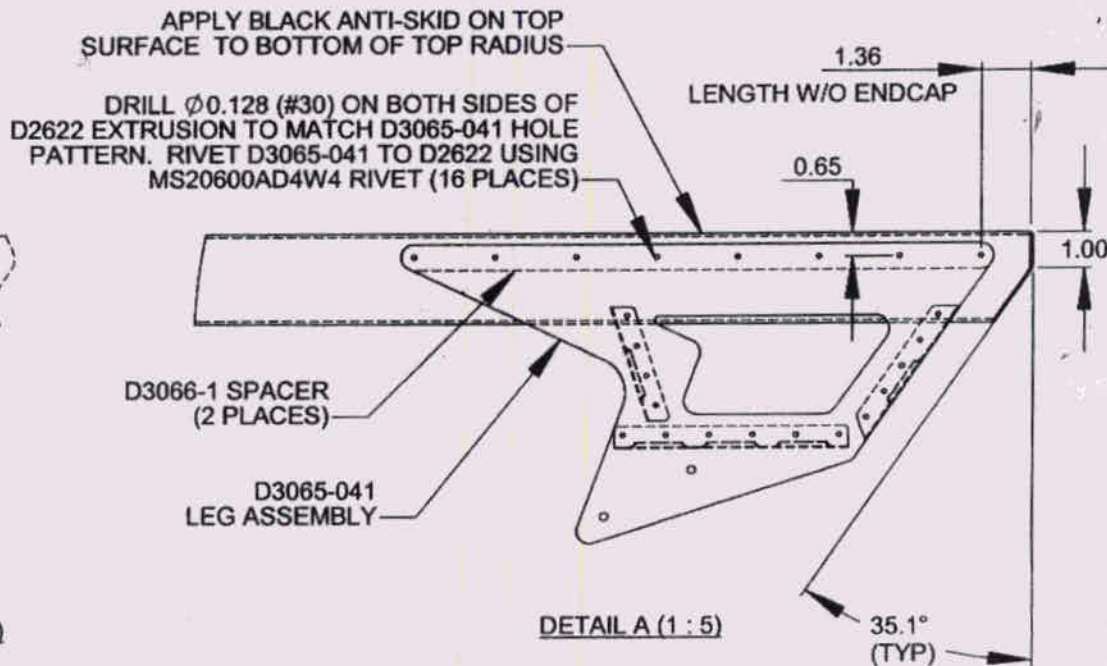
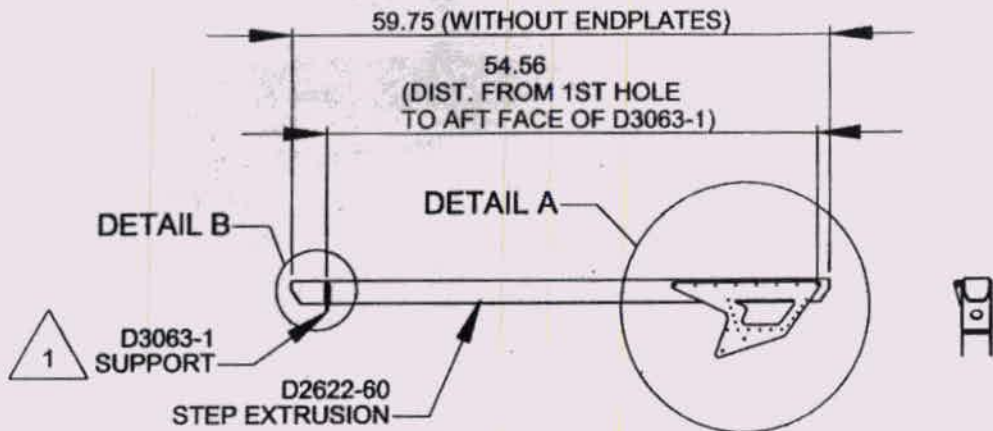
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DART



DESIGN	AP	DRAWN BY	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	AP	APPROVED	AP	DRAWING NO. D3078
DATE	02.09.11	TITLE	STEP ASSEMBLY, HI SHORT	REV. A SHEET 2 OF 2
		SCALE	1:20	

RELEASED
02.09.2004



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